

Work Order ID 152934

Monday, November 07, 2016 4:06:51 PM

152934

Page 1

Item ID: D3935-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pylon Wall Protector, LH
Start Date: 11/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: VS  Date: 12/11/18 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3935	B
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100

0.01

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3935

Dwg Rev: BProg Rev: B

2- Deburr if necessary

0.06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

PR 12/11/08

1

PR 12/11/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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DAS
21
9-89

DQA: _____ Date: _____

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		OTHER : ☐							

Picklist Print

Monday, November 07, 2016 4:06:51 PM

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Work Order ID: 152934

152934

Parent Item: D3935-1

D3935-1

Parent Item Name: Pylon Wall Protector, LH

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased			No	100	sf	1,385.302	8.69	10.22353			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

PR 16/11/08

Location

MAT018

m135074

Loc Qty

1385.302353

1385.30235

Loc Code

14.8

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
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Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
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Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD		Work Order: 157934
Description: Pylon Wall Protector, LH		Part Number: D3935-1
Inspection Dwg: D3935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.05	+/-0.030	8.05	✓		Rape	
15.05	+/-0.030	15.05	✓		Dr:02	
19.00	+/-0.030	19.00	✓			
19.25	+/-0.030	19.25	✓			
20.25	+/-0.030	20.25	✓			
23.25	+/-0.030	23.25	✓			
24.35	+/-0.030	24.35	✓			
29.25	+/-0.030	29.25	✓			
32.75	+/-0.030	32.75	✓			
1.00	+/-0.030	1.002	✓			
3.50	+/-0.030	3.50	✓			
9.00	+/-0.030	9.00	✓			
17.00	+/-0.030	17.00	✓			
18.50	+/-0.030	18.50	✓			
33.40	+/-0.030	33.40	✓			
34.25	+/-0.030	34.25	✓			
34.60	+/-0.030	34.60	✓			
34.72	+/-0.030	34.72	✓			
22.85	+/-0.030	22.85	✓			
19.15	+/-0.030	19.15	✓			
35.39	+/-0.030	35.39	✓			
0125	+/-0.010	0.132	✓			

Measured by: PR	Audited by: DAS 38	Preliminary Approval:	N/A
Date: 16/11/08	Date: NOV 11 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	
B	10.08.18	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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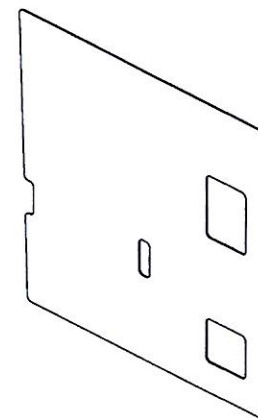
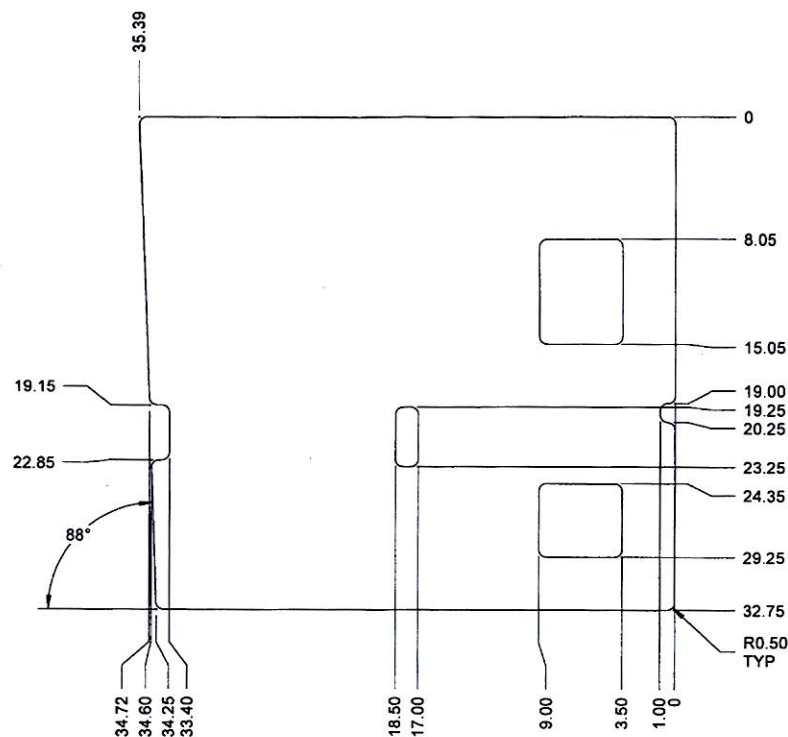
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OTHER : _____					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152934

VLC
12/11/8

0.125
REF



D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

RELEASED
2009-10-22

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	HS	09.08.19
A	NEW ISSUE	HS	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3935	REV. B SHEET 1 OF 4
TITLE PYLON PROTECTOR	SCALE NTS
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